

Work Order ID 57520

April 8, 2010 7:29:21 AM



Page 1

Item ID: D3204-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Release Pedal Assembly

Start Date: 4/08/10 Start Qty: 4.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. □2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. □3- Use JB weld compound to plug the hole after assembly. □4- Grind JB weld flush after it is cured. □Ident

EL 10-6-15 *(x4)*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

JE 10-06-15 *(x4)*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/6/15

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57520

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Page 2

Item ID:	D3204-041	Accept		Setup	Start	
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Start Date:	4/08/10	Start Qty:	4.00			
Required Date:	4/16/10	Req'd Qty:	4.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
140 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	***Cover holes for bushing*** 825 <input type="checkbox"/> START TIME: 825 <input type="checkbox"/> OVEN TEMPERATURE: 825 <input type="checkbox"/> FINISH TIME: 8:55								
150 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

H BK 10-6-16

H BK 10-6-16

=> H 10/06/16

4 0

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Install D3204-7 bushing as shown in Dwg D3204

EP 06/18 (4)

170

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S 06/18

(x4)

180

0.00

Identify as per dwg & Stock Location: *CA*

Packaging

Memo

0.00

Packaging

EP 06/18 (4)

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/21 *[Signature]*
MP
10-6-18

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

April 8, 2010 7:29:20 AM

Page 1

Work Order ID: 57520

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly


Comments: IPP: ☐ C ☐ 05.08.11 ☐ Added Step 25 ☐ KJ/JLM ☐

Start Date: 4/08/10

Required Date: 4/16/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3204-1  Tube		Manufactured	No			100	Each	5.0000	4.0000			

Warehouse Loc Qty Loc Code

Location


Main Warehouse

WA

5

55464

5

D3204-11  Plate		Manufactured	No			100	Each	3.0000	4.0000			
--	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location


Main Warehouse

WA

38

55463

38

D3204-13  Gusset		Manufactured	No			160	Each	17.0000	8.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

17

55365

17

EL 10-6-15

4

EL 10-6-15

4

EL 10-6-15

48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 57520

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 4/08/10


Required Date: 4/16/10

Comments: IPP: ☐C05.08.11 ☐Added Step 25 ☐ KJ/JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3204-3		Manufactured	No			100	Each	7.0000	4.0000			
												
Arm												

Warehouse Loc Qty Loc Code

Location


Main Warehouse

WA

7

47570

7

D3204-5		Manufactured	No			100	Each	6.0000	4.0000			
												
Arm												

Warehouse Loc Qty Loc Code

Location


Main Warehouse

WA

6

43763

6

D3204-7		Manufactured	No			100	Each	29.0000	8.0000			
												
Bushing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST045

29

46971

5

48631

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3204-041



Parent Item Name: Release Pedal Assembly


Start Date: 4/08/10

Required Date: 4/16/10

Comments: IPP: ☐C☐05.08.11☐Added Step 25☐ KJ/JLM☐

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3204-9  Pedal		Manufactured	No			100	Each	13.0000	4.0000			



PL 10-6-15

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	13	
43765	5	
56311	8	

4

W/O:		WORK ORDER CHANGES					
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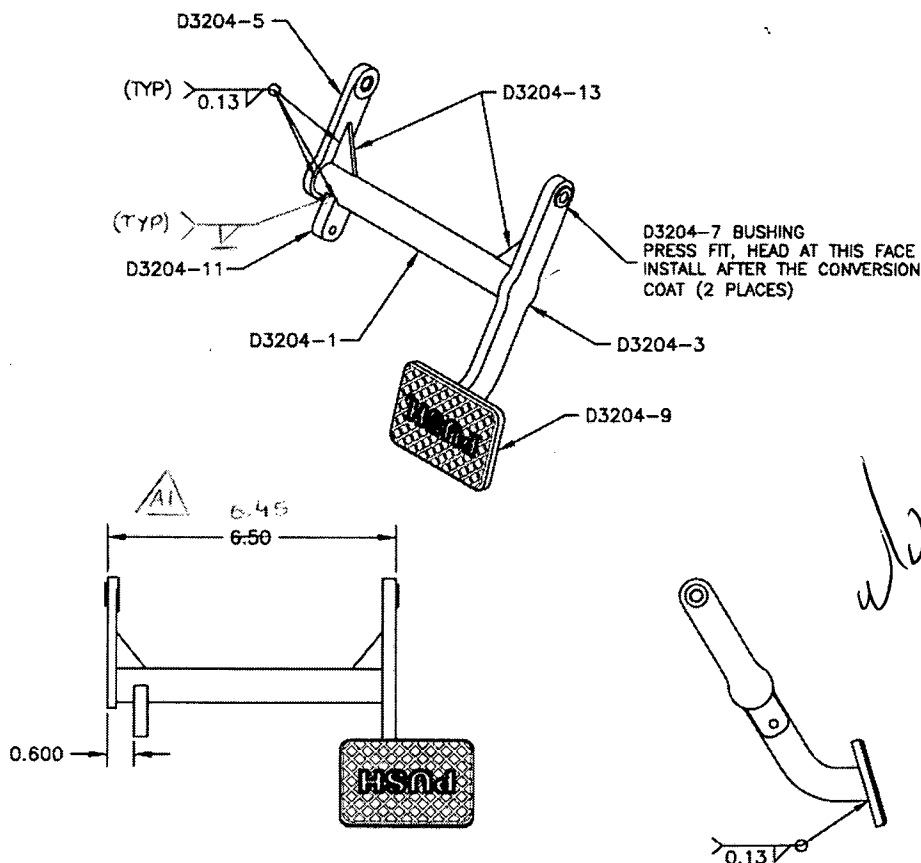
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DESIGN 4	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04 30 1



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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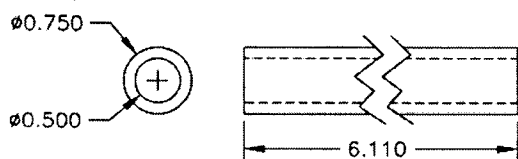
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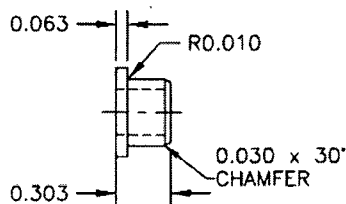


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

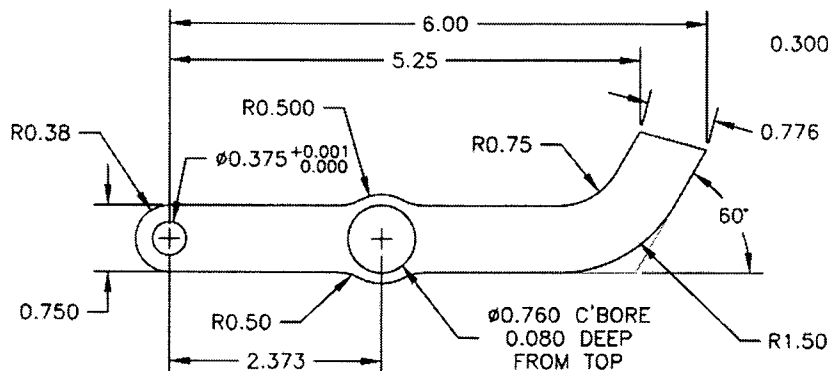
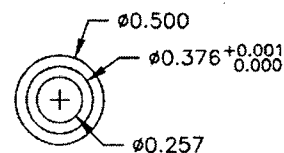
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04.04.05 *[Signature]*



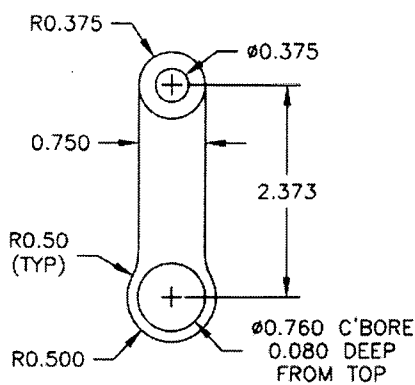
2 D3204-1 TUBE
SCALE 1:2



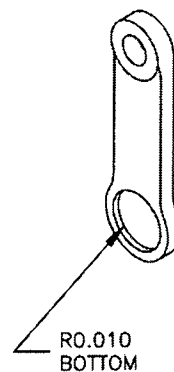
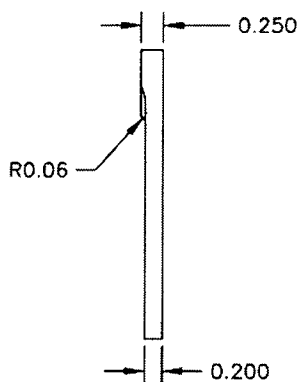
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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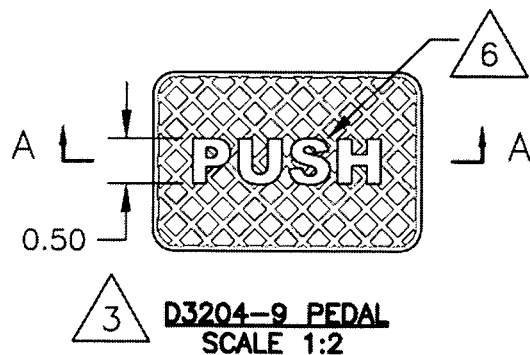
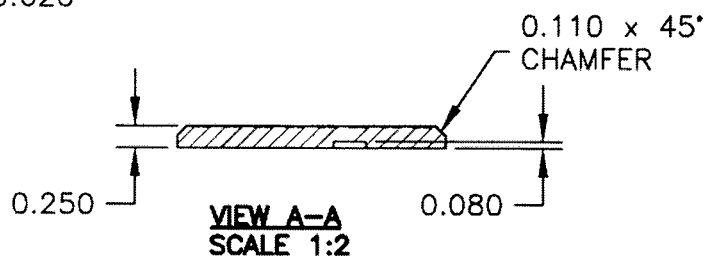
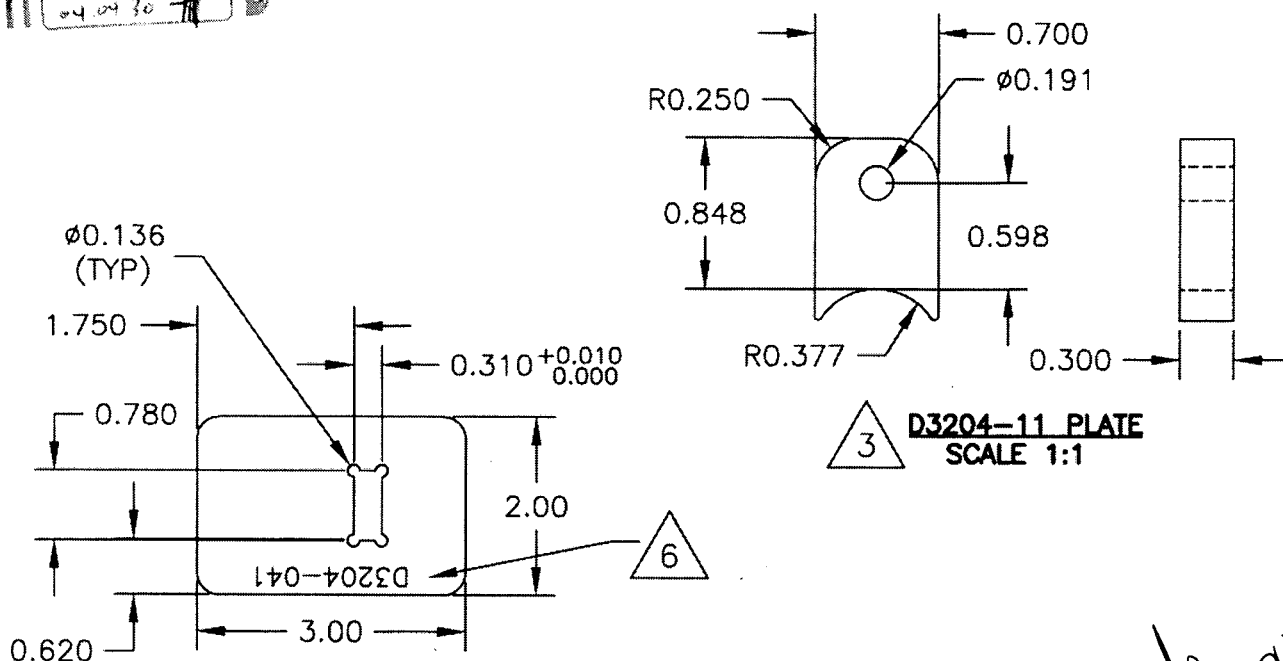
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DESIGN <i>TJ</i>	DRAWN BY <i>TJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.30



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